



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11842	45/55
2	Machined By		V.T.L. n/c Shop	Dy. H.O. E.C. 1951
3	Pallet Die No.		12433 (8.0) H-H	Rev. 00
4	Die Category	Drg. No.	Extrusion Die	
5	Out Side Diameter	Drg. No.	630 H-H, Step OD: 621.5 H-H	Tapper 12°
6	Inside Diameter	Drg. No.	520.12 H-H	Step length: 1.5
7	Width of Pellet Die	Drg. No.	222 H-H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H-H 13x8x5 H-H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No. of Holes - 12 Both Side
12	Tapping PCD		565 H-H	
13	Tapping Hole Diameter		H20: Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 20.8 H-H	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 8/5/24

1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	OK	
4	Defective Holes (If Any)		No	

Note: Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK						Counter 280° Law = 18
2	External Relief Dia	8.5 H-H	60 Side (23-3)		Inner			
3	External Relief Depth	/	18 H-H		10 H-H			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		8	5	24			
Inspected By (Sign) & Date		Ravi 8/5/24						

Reviewed by (Engineer-CNC)

Manager-QA